

# Work Order ID 79352

**\*79352\***

Page 1

Wednesday, January 25, 2012 12:01:40 PM

Item ID: D4108-047 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Sill Doubler Assembly  
 Start Date: 1/25/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 2/3/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4108	B

110		0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AS PER DWG								

6 ~~φ~~ FF 12-04-26

120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

8/26/26 (26) φ

130	Identify as per dwg & Stock Location: <u>85 129</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									

6x SP 12-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79352****\*79352\***

Page 2

Wednesday, January 25, 2012 12:01:40 PM

Item ID: D4108-047

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Sill Doubler Assembly

Start Date: 1/25/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

1/24/30 JF  
1/204-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 25, 2012 12:01:48 PM

Page 1

Work Order ID: 79352

**\*79352\***

Parent Item: D4108-047

**\*D4108-047\***

Parent Item Name: Sill Doubler Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD IPP  
Rev:B 10.12.03 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3622-1 Manufactured No

110

Each

44.0000

1

6

**\*D3622-1\***

**\*\***

Ball Stud

Location

Loc Qty

Loc Code

ST058

44

B80405

76889

14

78837

30

NAS1149C0532R

Purchased

No

110

Each

533.0000

2

12

**\*NAS1149C0532R\***

**\*\***

WASHER

Location

Loc Qty

Loc Code

ST297

533

116373

1

116513

53

118384

79

119736

400

12

(6) FF 12-04-26

(6) FF 12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Wednesday, January 25, 2012 12:01:48 PM

Work Order ID: 79352

**\*79352\***

Parent Item: D4108-047

**\*D4108-047\***

Parent Item Name: Sill Doubler Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 6.00

Required Qty: 6.00

MS21043-5

Purchased

No

110

Each

577.0000

1

6

**\*MS21043-5\***

\*\*

(6) FF 12-04-26

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

132

112314

132

ST301

425

116548

100

118159

100

119307

25

119537

200

6

D4108-7

Manufactured

No

110

Each

0.0000

1

6

**\*D4108-7\***

\*\*

(6) FF 12-04-26

Bracket

B 76483

Wednesday, January 25, 2012 12:01:48 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

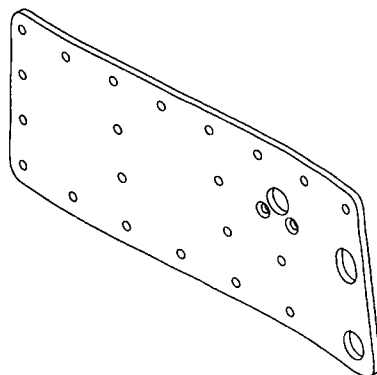
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

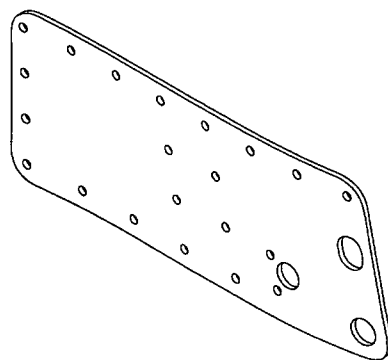
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4108-1 LEFT PASS DOOR DOUBLER**



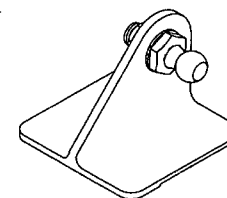
**D4108-3 RIGHT PASS DOOR DOUBLER**



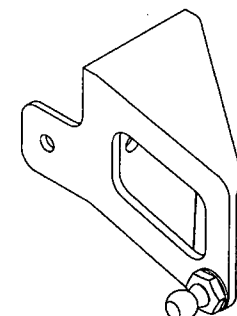
**D4108-5 SMALL RIGHT DOOR DOUBLER**



**D4108-11 TEMPLATE**



**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-049 LITTER DOOR FITTING ASSEMBLY**

STRICTLY COPY  
RELATES TO  
IDENTICAL  
UNCONTROLLED COPY  
SUBJECT TO COMMENT  
WORK ORDER  
NO. 793524.25  
12/01/25

**RELEASED**  
2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 8061-T6 AL. NOTES UPDATED (SHT 5,6)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4108</b>	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>DOUBLERS &amp; FITTINGS</b>	NTS
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

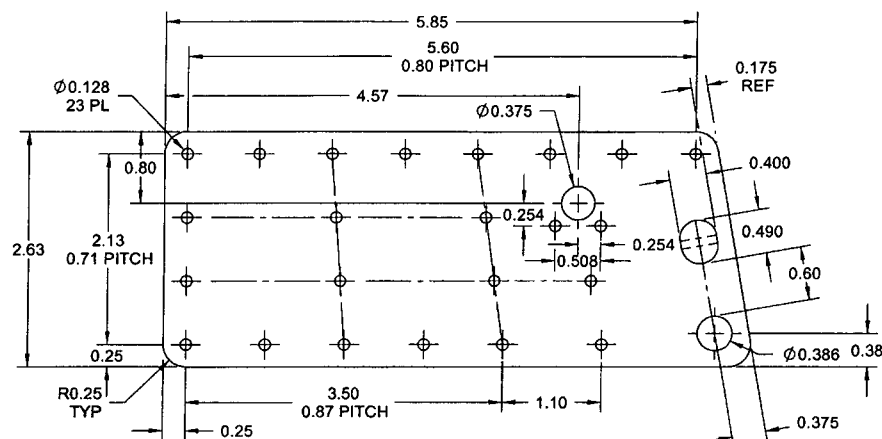
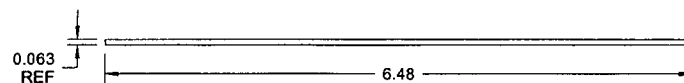
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

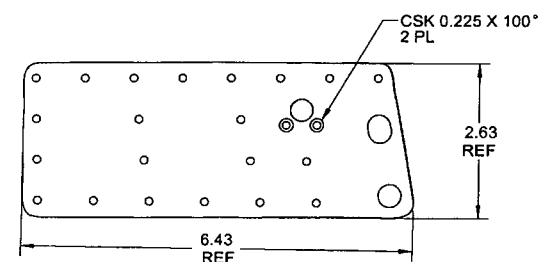
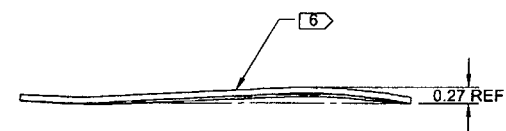
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79352



**D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER**



**D4108-1 LEFT PASS DOOR DOUBLER (MAKE FROM D4108-1F)**

**NOTES:**

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA
- 1 : MAKE FROM D4108-1F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9648.

RELEASED  
2010-11-30  
wp

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4108</b>	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

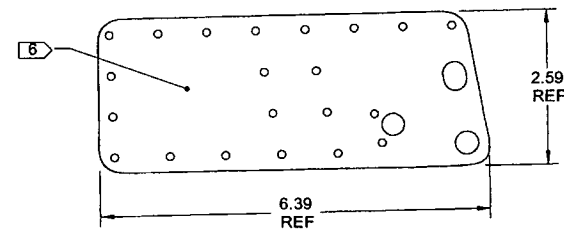
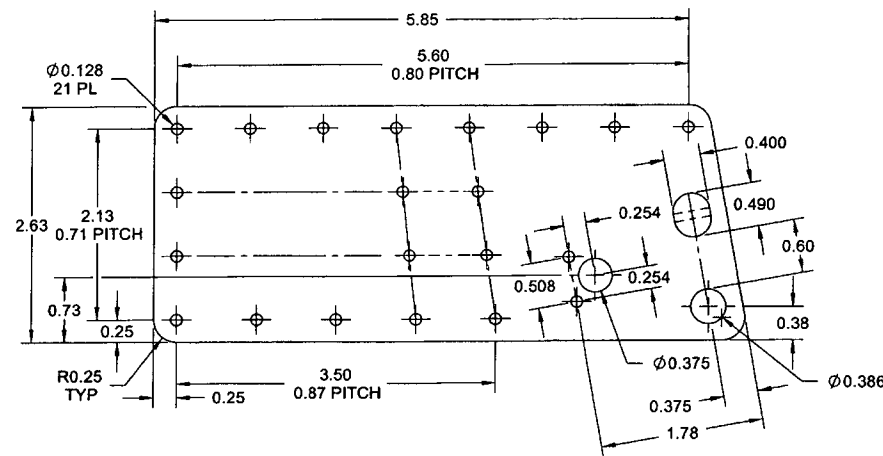
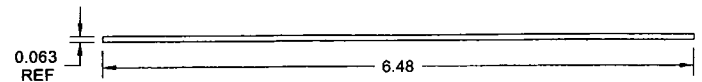
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79352

8 7 6 5 4 3 2 1



**D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER**

**D4108-3 RIGHT PASS DOOR DOUBLER (MAKE FROM D4108-3F)**

- NOTES:
- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA  
-3 : MAKE FROM D4108-3F.
  - 2) FINISH: NONE.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
  - 7) WEIGHT: 0.29 lbs
  - 8) FORM & INSPECTION PER TEMPLATE DT9849.

RELEASED  
2010-11-30

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D4108	REV. B
MFG. APPR.			SHEET 3 OF 7
APPROVED		TITLE DOUBLERS & FITTINGS	SCALE NTS
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DATE	10.11.01		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79352

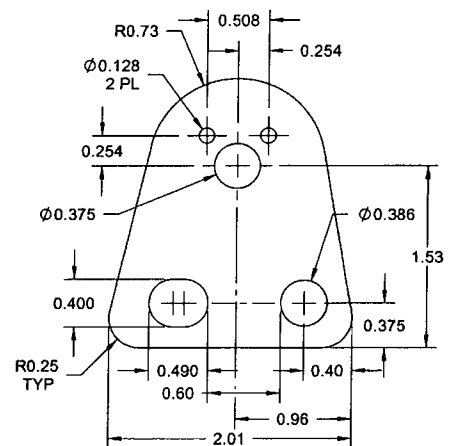
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D

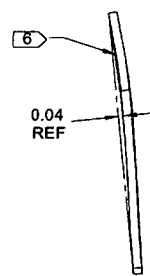
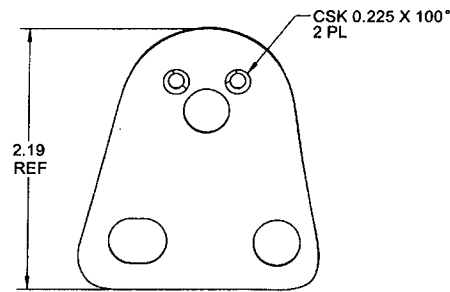
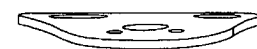
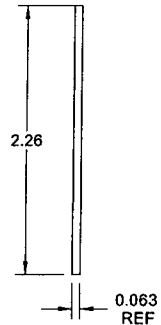
C

B

A



**D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER**







**D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)**

**NOTES:**

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-5: MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

RELEASED  
2010-11-30

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

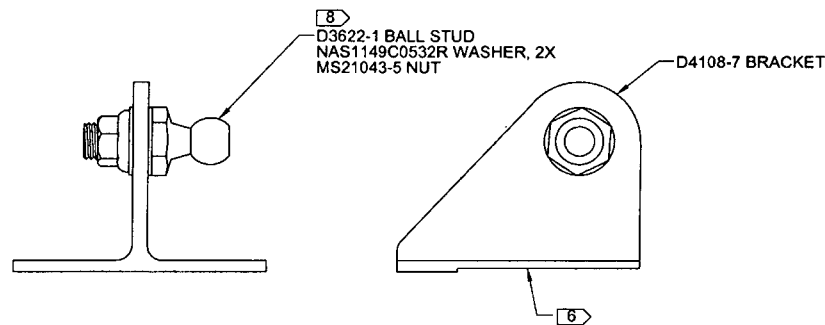
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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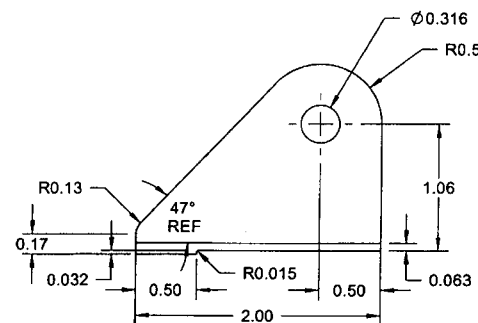
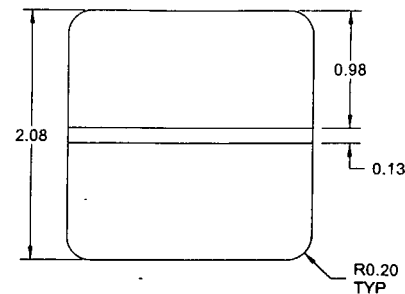


79352

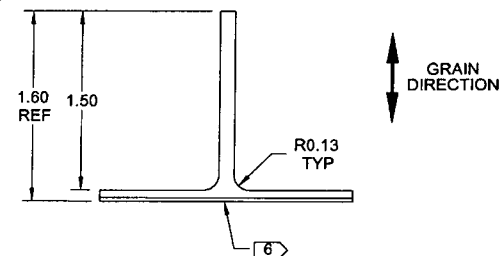
Qty	Part Number	Description
-047	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-7 BRACKET**



- NOTES:**
- 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - 7) WEIGHT -047: 0.10 lbs
  - 8) TORQUE TO 5-10 INCH POUND.

RELEASED  
2010-11-03

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4108	SHEET 5 OF 7
APPROVED	JPH	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

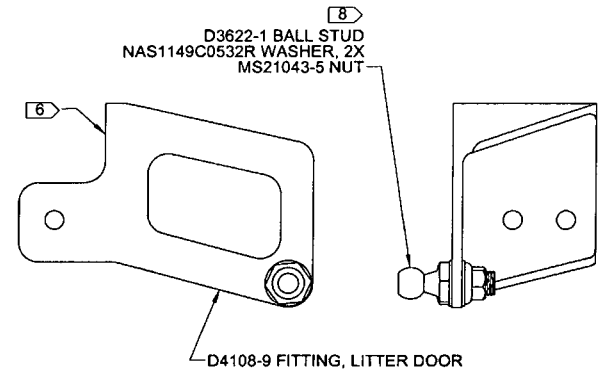
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

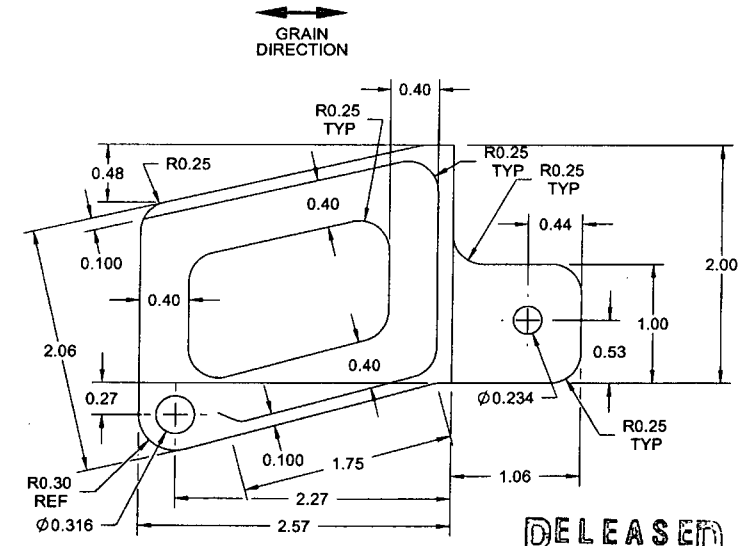
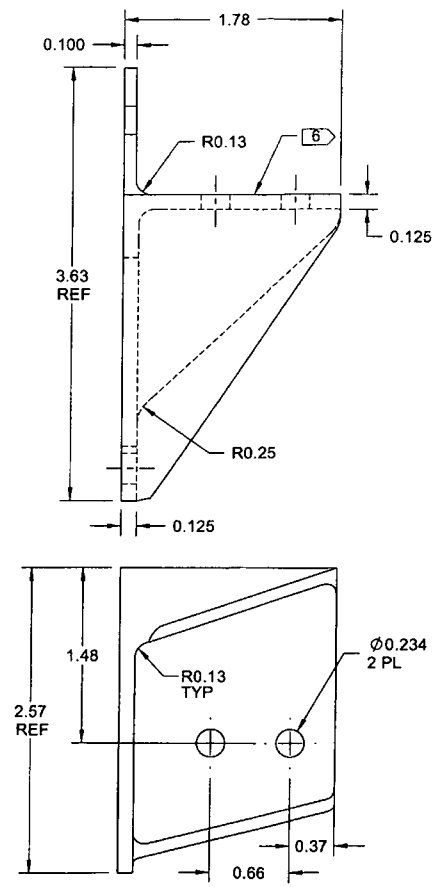
**NOTE:** Date & initial all entries

79352

Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER






**D4108-049 LITTER DOOR FITTING ASSEMBLY**



**D4108-9 FITTING, LITTER DOOR**

- NOTES:**
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - 7) WEIGHT -049: 0.19 lbs
  - 8) TORQUE TO 15 INCH POUND.

RELEASED  
2010-11-30

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

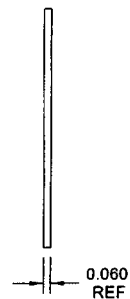
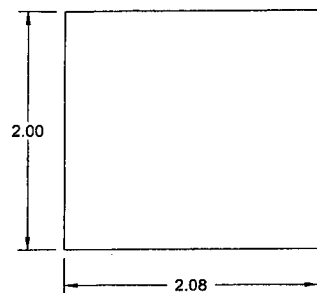
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79352



**D4108-11 TEMPLATE**

RELEASED  
2010-11-30  
NA

**NOTES:**

- 1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1
- 7) WEIGHT: N/A

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4108</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE <b>DOUBLERS &amp; FITTINGS</b>	SHEET 7 OF 7
DE APPR.	<i>[Signature]</i>	SCALE <b>NTS</b>	
DATE	10.11.01	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries